

Work Order ID 58751

Tuesday, May 18, 2010 11:29:09 AM

Page 1

Item ID: D3259-7

Accept

Setup Start

Revision ID:

Item Name: Door

Stop

Start Date: 5/18/2010 Start Qty: 10.00

Required Date: 5/25/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *PP* Date: *10-5-18* Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3259

Rev A1

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3259

☐ Dwg Rev: *A1* ☐ Prog Rev: *A1* ☐ 2-

Deburr if necessary

 2024 .063 *FB10-5-19* *(12)*

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

 FB10-5-19

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

 8/20/20 *(FH)* *P10 ->*

W/O: 58751		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/5/20	# 120	Took Qty +1 For inspection template	S	10/05/20	21		S 10/05/20

Part No: D3259-7 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58751

Tuesday, May 18, 2010 11:29:09 AM



Page 2

Item ID: D3259-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Door

Start Date: 5/18/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11 BR 10-5-20

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JH 10/05/20

11 8

150

Identify as per dwg & Stock Location: 180

0.00



Packaging

Memo

0.00

Packaging

10-5-25 1102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 58751

Tuesday, May 18, 2010 11:29:09 AM



Page 3

Item ID: D3259-7

Accept



Setup Start



Revision ID:

Item Name: Door

Stop



Start Date: 5/18/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/2010

C2 10/05/2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 18, 2010 11:29:13 AM

Page 1

Work Order ID: 58751



Parent Item: D3259-7



Parent Item Name: Door



Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	172.5000	1.388	16.6		
												
2024-T3 .063 sheet												
												
B105-19												

Location

Loc Qty

Loc Code

MAT22

172.5

111787

2

113866

19.2

113867

19.1

114351

132.2

113867

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58751
Description: Door		Part Number:	D3259-7
Inspection Dwg: D3259	Rev: A1		
		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.008	+/-0.010	10.008	✓			
9.000	+/-0.005	9.004	✗			
1.000	+/-0.005	1.001	✓			
0.260	+/-0.010	0.262	✓			
R0.130	+/-0.010	0.130	✓			
5.960	+/-0.010	5.961	✓			
0.548	+/-0.010	0.550	✓			
0.626	+/-0.010	0.618	✓			
11.250	+/-0.005	11.248	✓			
Ø0.313	+0.005/-0.000	0.314	✓			
Ø0.098	+0.005/-0.000	0.100	✓			
3.308	+/-0.010	3.308	✓			
R0.46	+/-0.030	0.46	✓			
0.063 thick	+/-0.010	0.063	✓			
0.059	+/-0.010	0.057	✓			

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-5-19	Date:	10/5/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue	KJ/JLM	

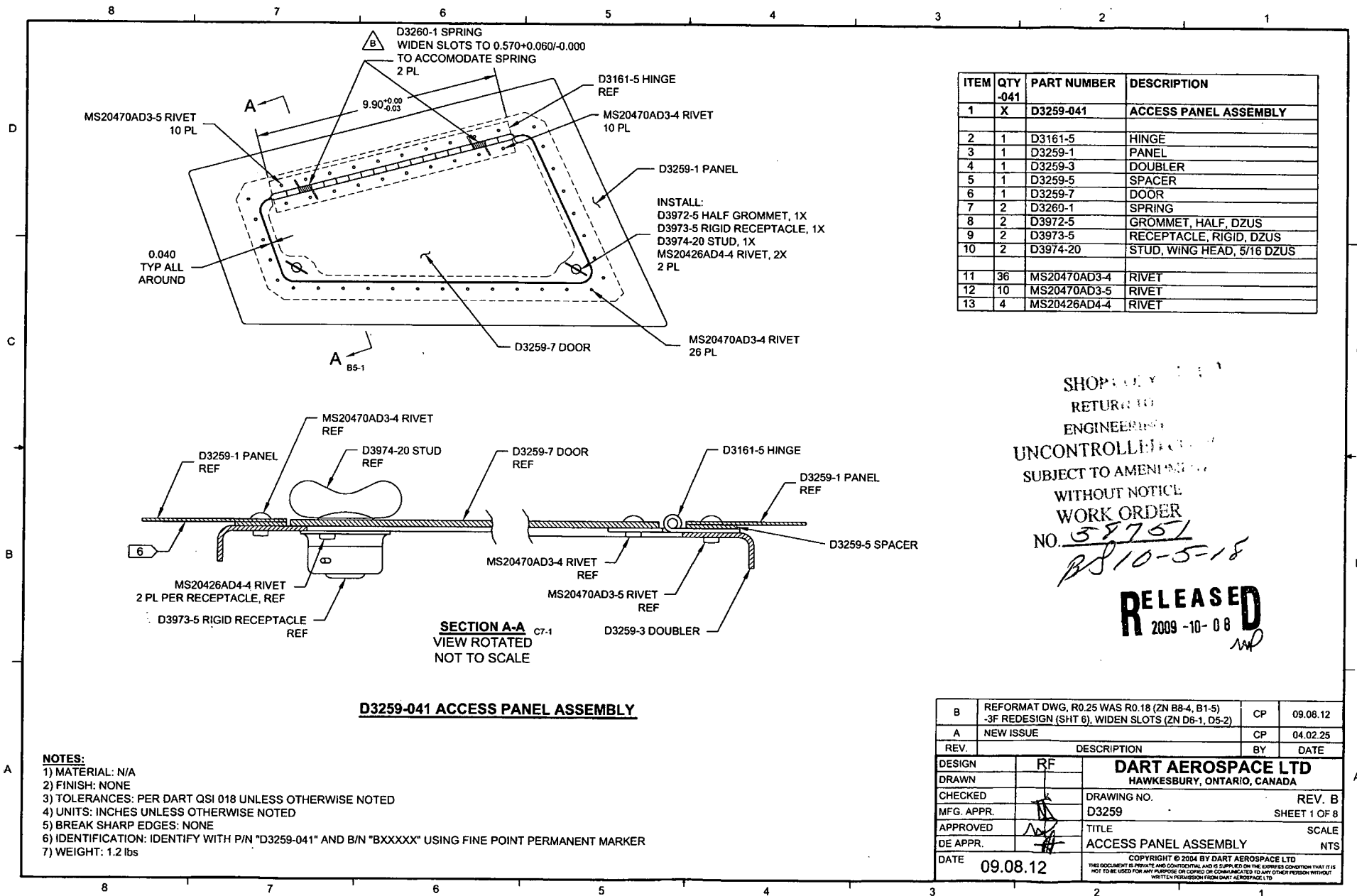
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



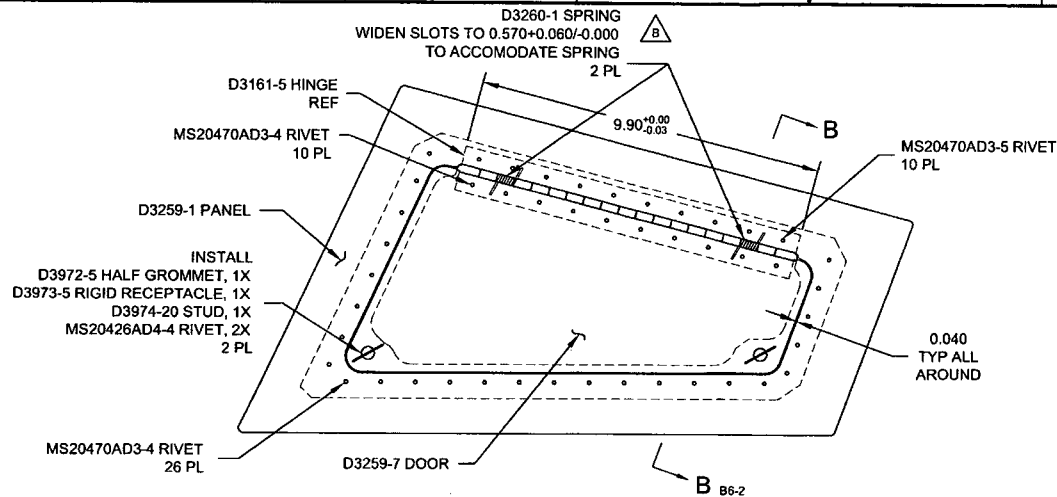
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

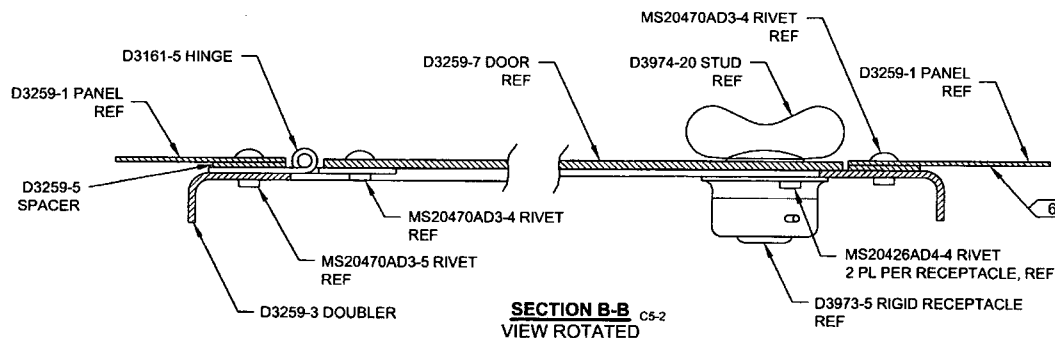
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



D3259-042 ACCESS PANEL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

RELEASED
2009-10-08

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3259	SHEET 2 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD	
DATE	09.08.12	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

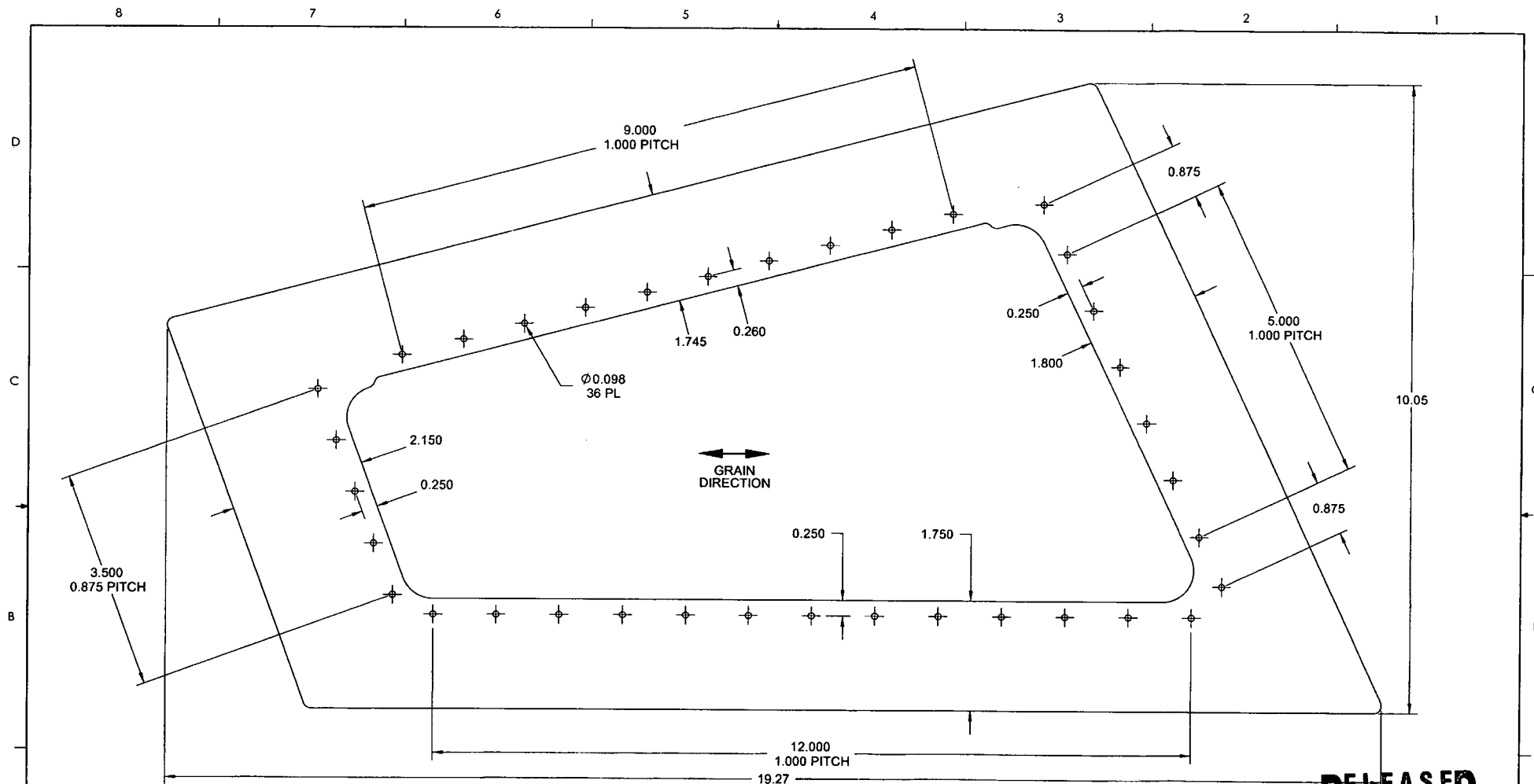
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3259-1 PANEL

W/O 5875,

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.25 lbs
- 8) MAKE PER DWG FILE "D3259-1B.DXF"

DESIGN	<i>DF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3259 TITLE ACCESS PANEL ASSEMBLY COPYRIGHT © 2004 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION. PROPRIETARY. AEROSPACE LTD.</small>	REV. E
DRAWN	<i>DF</i>		SHEET 3 OF 3
CHECKED	<i>DF</i>		
MFG. APPR.	<i>DF</i>		
APPROVED	<i>DF</i>		
DE APPR.	<i>DF</i>		
DATE	09.08.12		NTS

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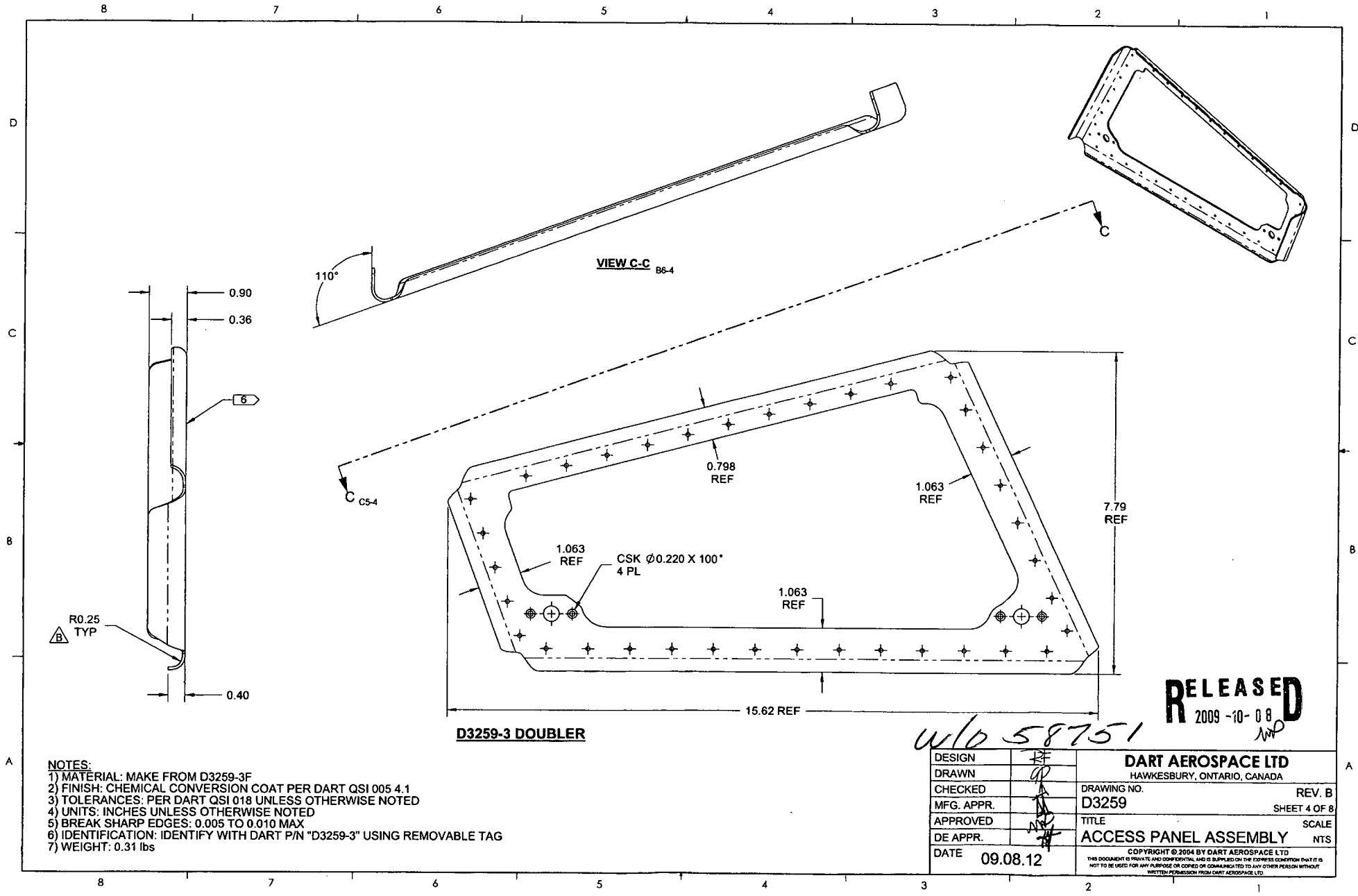
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3259-3 DOUBLER

- NOTES:**
- 1) MATERIAL: MAKE FROM D3259-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3" USING REMOVABLE TAG
 - 7) WEIGHT: 0.31 lbs

RELEASED

2009-10-08

WLD 58751

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D3259	SHEET 4 OF 8
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	ACCESS PANEL ASSEMBLY NTS	
DATE 09.08.12		<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

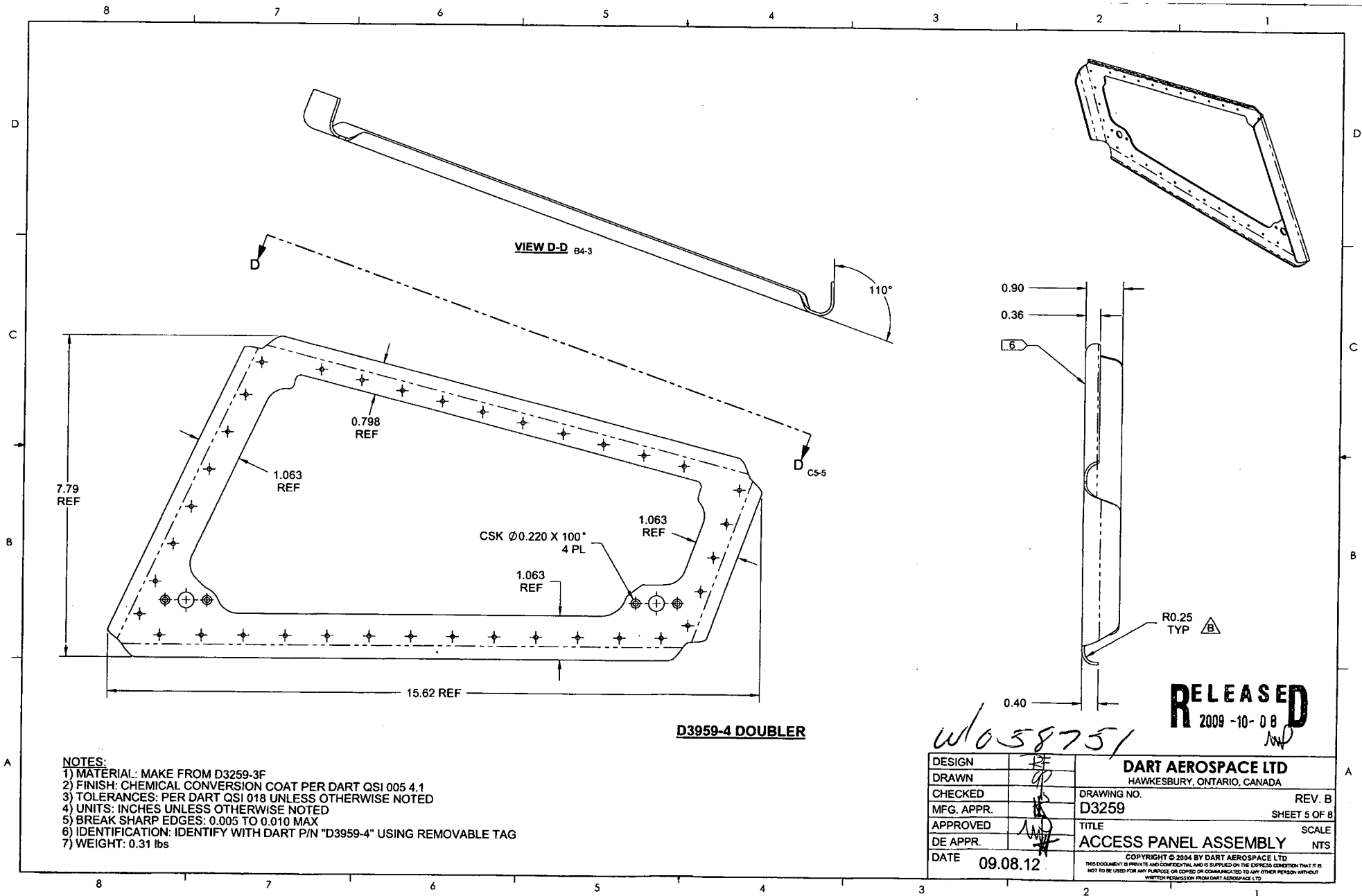
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: MAKE FROM D3259-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3959-4" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs

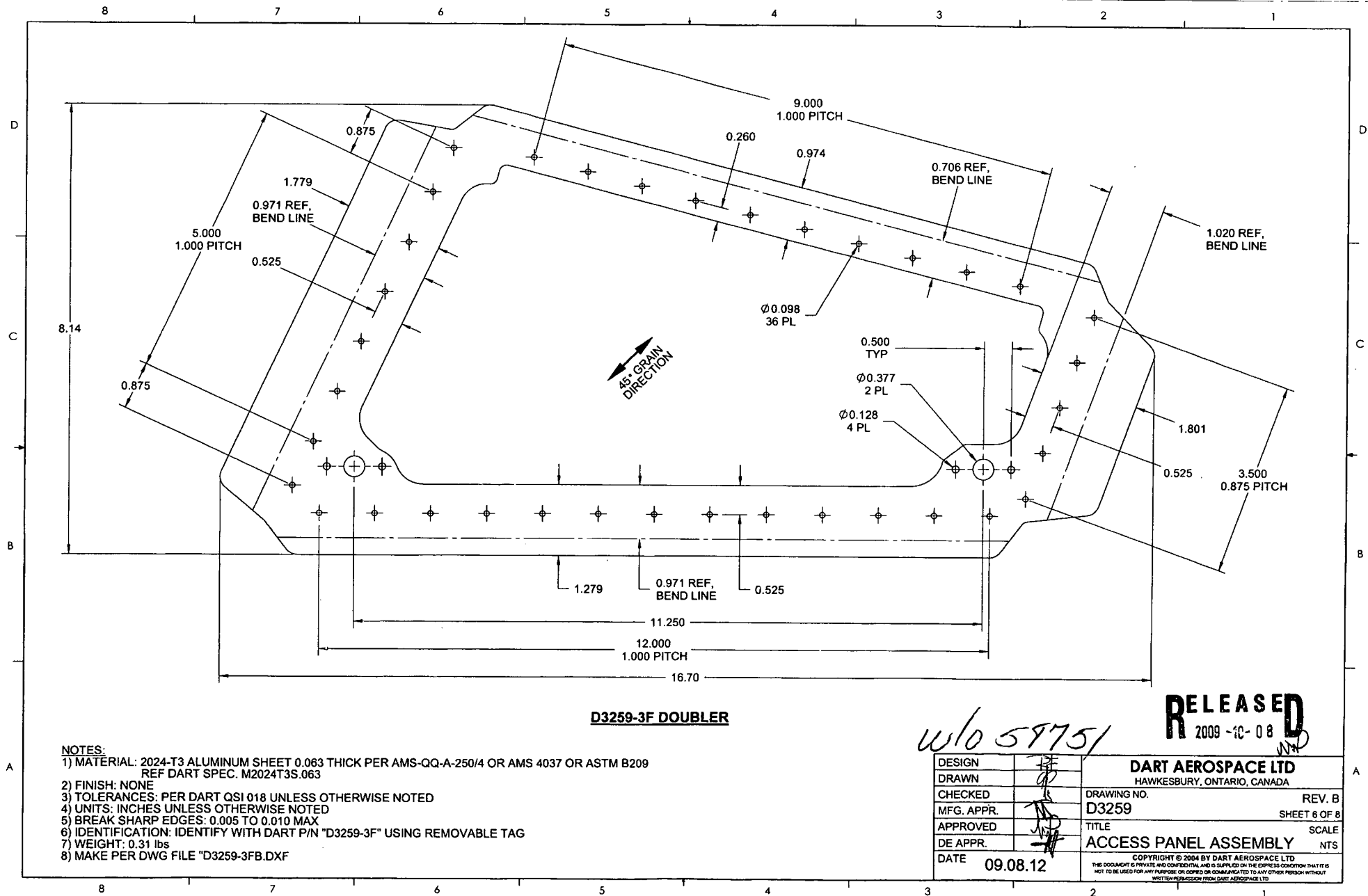
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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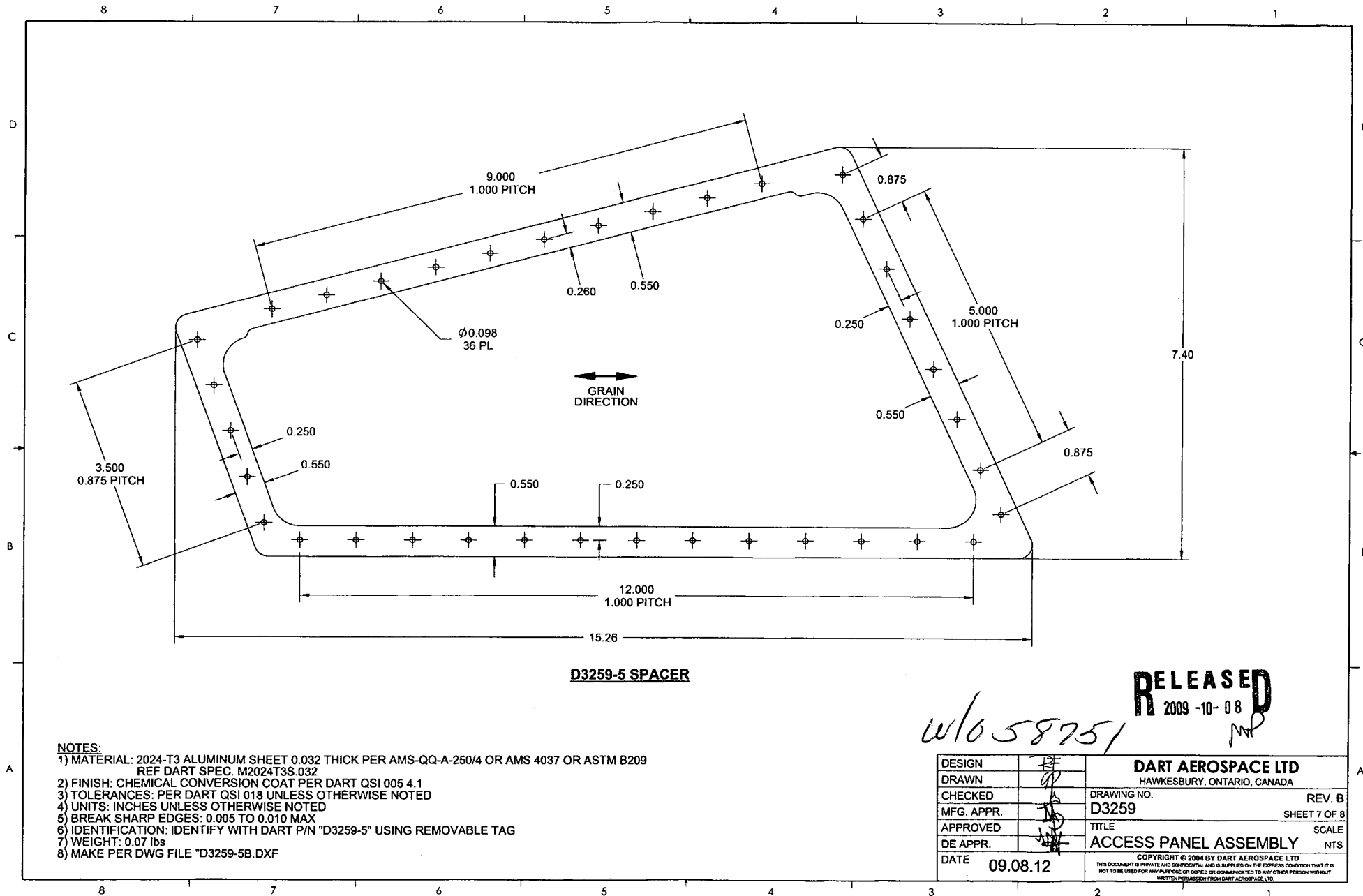
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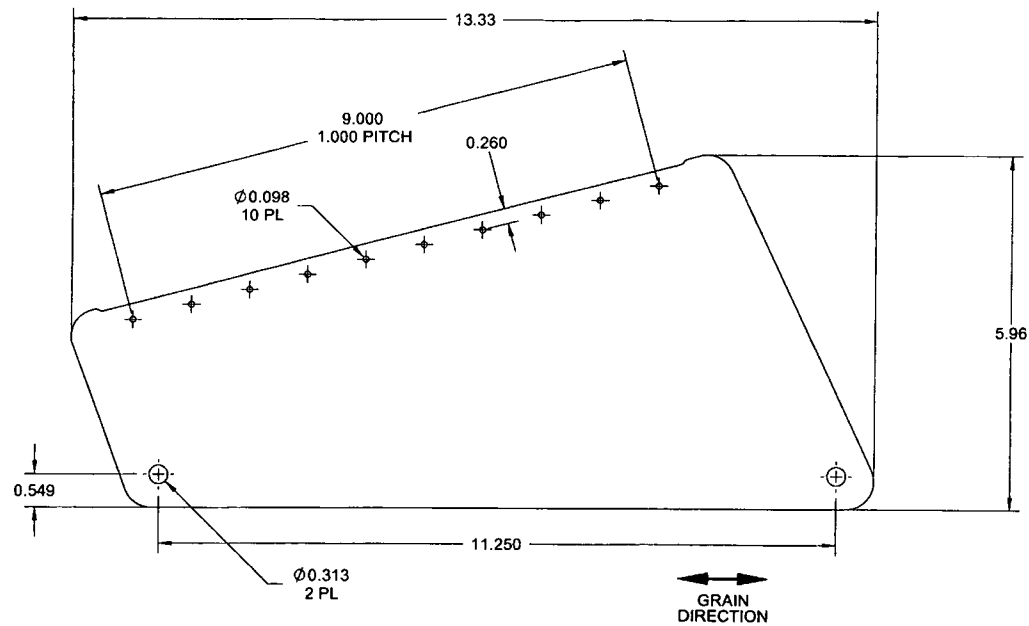
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3259-7 DOOR

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

RELEASED
2009-10-08

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
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